

**Work Order ID 85103**

Friday, June 01, 2012 4:04:23 PM

**\*85103\***

ASAP

Page 1

Item ID: PB67-43001-137

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Locking Sleeve

Start Date: 6/1/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-06-04* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

**\*100\***

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA Rev: \_\_\_\_\_ &amp; Dwg B67-43001-1 Rev: \_\_\_\_\_

2-Deburr per dwg B67-43001-1

*CA 12619*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*CA 12619*

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*ant 12/06/09**4*

W/O: 85103		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B-67-43001-137 PAR #: \_\_\_\_\_ Fault Category: Machin NCR: Yes No DQA: Aut Date: 12/06/28  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 12/06/29

NCR: 12-1545		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/28	#102	Part Chx1 Feared with dent dentin Alouin. Rc. Mat. mark / missen Darin machin + insp. h09	S asrar 12/06/28	<del>Scrap + Destroy and Repair</del> M <u>NO Repair</u> Chx1	ll 12-06-27	S 12/06/28	S asrar 12/06/28	S 12/06/28

NOTE: Date &amp; initial all entries

# Work Order ID 85103

**\*85103\***

Page 2

Friday, June 01, 2012 4:04:23 PM

Item ID: PB67-43001-137

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Locking Sleeve

Start Date: 6/1/2012 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start <b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop <b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00				3	16	12-6-26	
Hand Finishing									
140	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
<b>*140*</b>	<i>M 18 KH.</i>								
Powdercoat	Memo	0.00				3	0	12-6-26	
Powder Coating	***Mask inside sleeve*** START TIME: <i>3:25</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>3:55</i>								
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

*5/17/04/27*

*(B)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85103****\*85103\***

Page 3

Friday, June 01, 2012 4:04:23 PM

Item ID: PB67-43001-137

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Locking Sleeve

Start Date: 6/1/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: UAA

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

3 *[initials]* 12.06.27

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/6/27 *[initials]*  
ME  
12-06-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 01, 2012 4:04:23 PM

Page 1

Work Order ID: 85103

Parent Item: PB67-43001-137

Parent Item Name: Locking Sleeve

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.08.29New issueKJ/JLM  
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	32.8999	0.178	0.7994737			
6061T6 RD TUBE 1.00 x .065w													

Location

MAT015

114089

116720

117983

Loc Qty

32.89988

0.3114

2

30.58848

Loc Code

SN 121619

8 pt

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

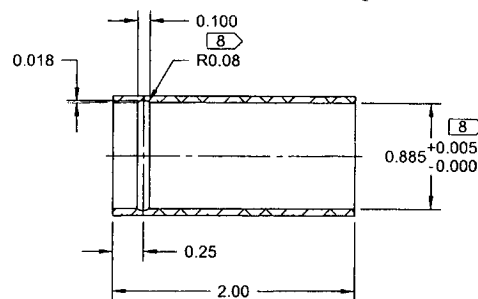
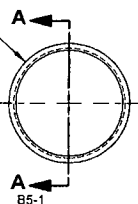
4

3

2

1

Ø1.00  
REF

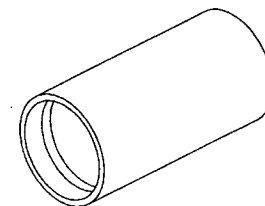


**SECTION A-A** C8-1

**B67-43001-137 LOCKING SLEEVE**

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING  
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR  
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF. DART SPEC. M6061T6T1.000V.065
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) MASK INSIDE SURFACES OF LOCKING SLEEVE PRIOR TO PAINTING



#85103

**RELEASED**  
2009-08-24  
NW

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 35 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	AS		DRAWING NO.	REV. C
MFG. APPR.			B67-43001-137	SHEET 1 OF 1
APPROVED	AK		TITLE	SCALE
DE APPR.	N/A	LOCKING SLEEVE	NTS	
DATE	09.02.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

